








Work Order ID 59150

Thursday, May 27, 2010 9:21:14 AM




Page 1


Item ID: D3535-25 Accept  Setup Start 
Revision ID: Stop 
Item Name: Wearshoe
Start Date: 5/27/2010 Start Qty: 12.00  Cust Item ID:
Required Date: 6/4/2010 Req'd Qty: 12.00  Customer:
Reference:


Approvals: Process Plan: PL Date: 10-5-27 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3535	Rev B								

100  0.00
Waterjet FLOW WATER JET
Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary
304 . 040 B 10-5-31 (13)

110  0.00
QC QC2- Inspect parts off machine FAI/FAIB
Memo 0.00
Quality Control B 10-5-31

120  0.00
QC QC8- Inspect parts - second check
Memo 0.00
Quality Control 810605/31 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59150

Thursday, May 27, 2010 9:21:14 AM

Page 2

Item ID: D3535-25

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 5/27/2010 Start Qty: 12.00

Required Date: 6/4/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

NC BRAKE

Memo

0.00

0.00

Brake NC

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326
2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

SB 10/05/31

13

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S. 10/05/31

(713)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

M112580

Memo

0.00

0.00

START TIME:

7:30 AM

FINISH TIME:

OVEN TEMPERATURE:

320°F

=) W 10/06/08

13

0

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 59150

Thursday, May 27, 2010 9:21:14 AM



Page 3

Item ID: D3535-25

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/27/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

13 BR 10-6-3

170

Identify as per dwg & Stock Location: FR-58

0.00



Packaging

Memo

0.00

Packaging

13 0

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/04

BR 10-6-3
(13)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, May 27, 2010 9:21:19 AM

Page 1

Work Order ID: 59150



Parent Item: D3535-25



Parent Item Name: Wearshoe

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A New Issue 07-02-15 JLM

Start Qty: 12.00

Required Qty: 12.00

IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	172.9926	0.51	6.442105	6.6		



304/316 .040 Sheet



B10-5-31

Location

Loc Qty

Loc Code

MAT

168.7278

114574

168.7278

MAT20

4.2648

112885

2.7475

113062

1.5173

114574

(13)

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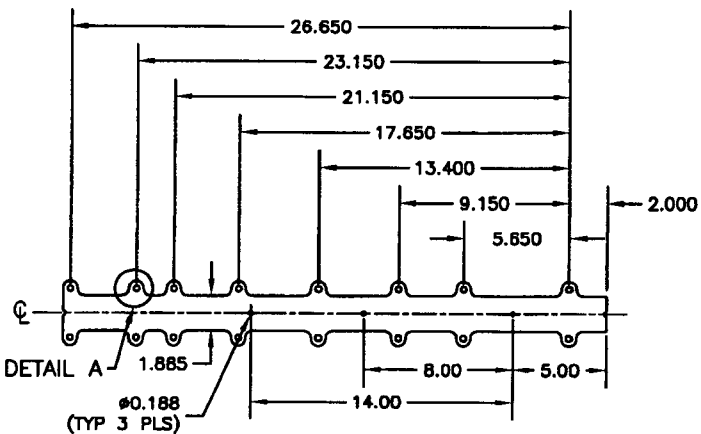
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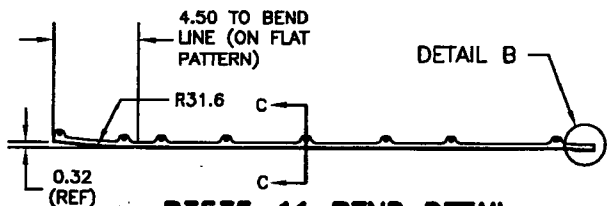
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07.04.17

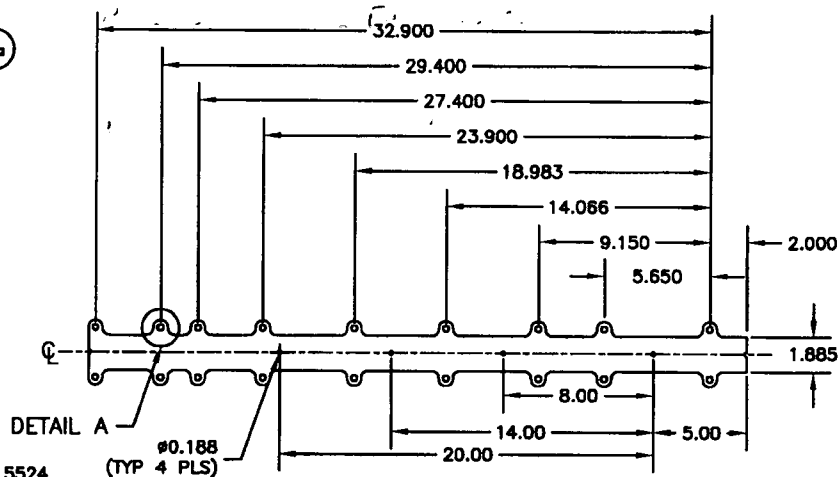
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59150
P8-0-527



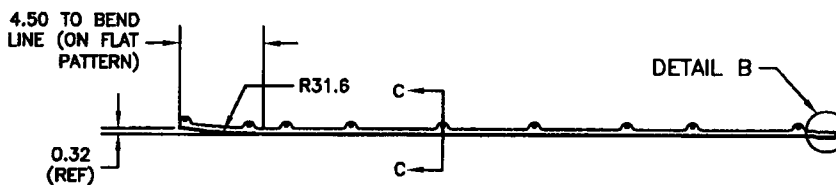
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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CHECKED	APPROVED	DRAWING NO.	REV. B
07.04.17	07.04.17	D3535	SHEET 1 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17	06.10.25	NEW ISSUE	1:10
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES					
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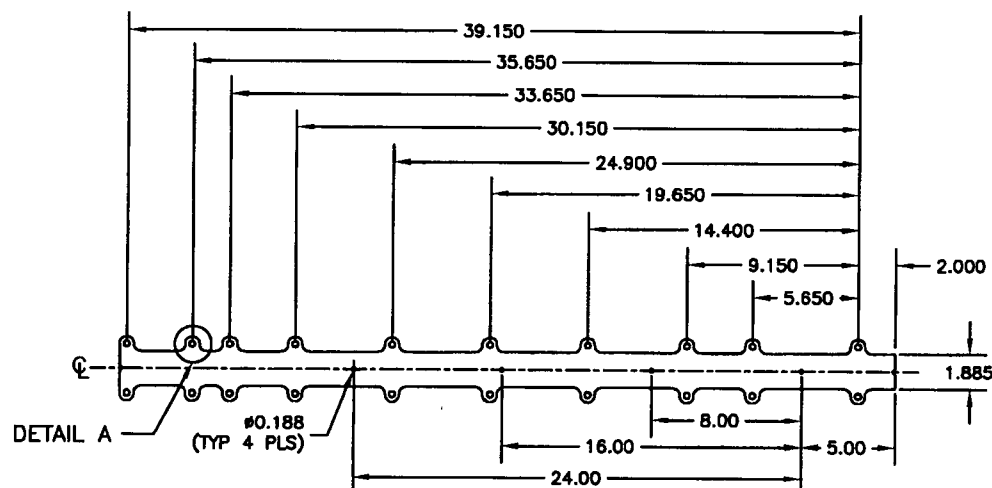
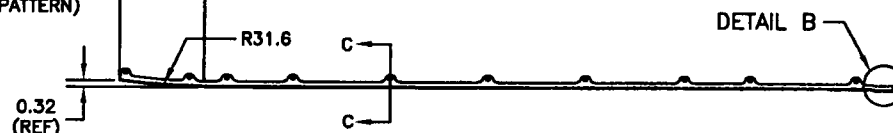
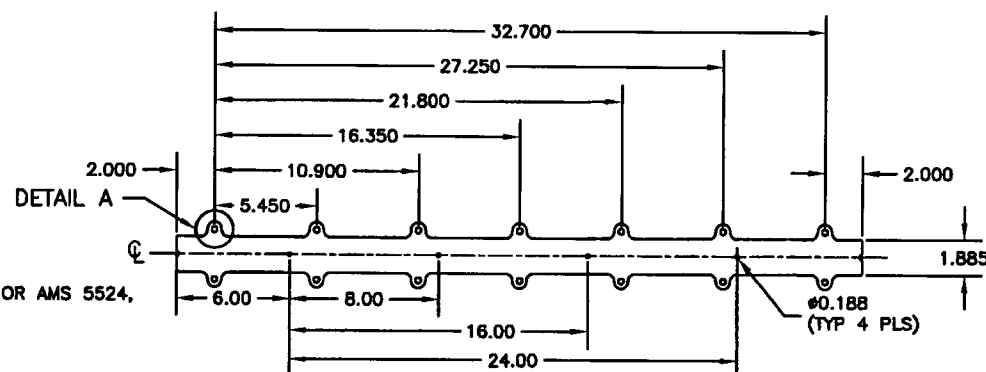
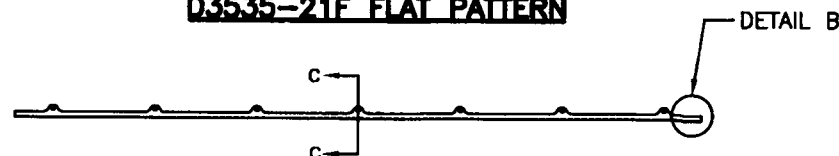
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<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 2 OF 7
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10

4.50 TO BEND
LINE (ON FLAT
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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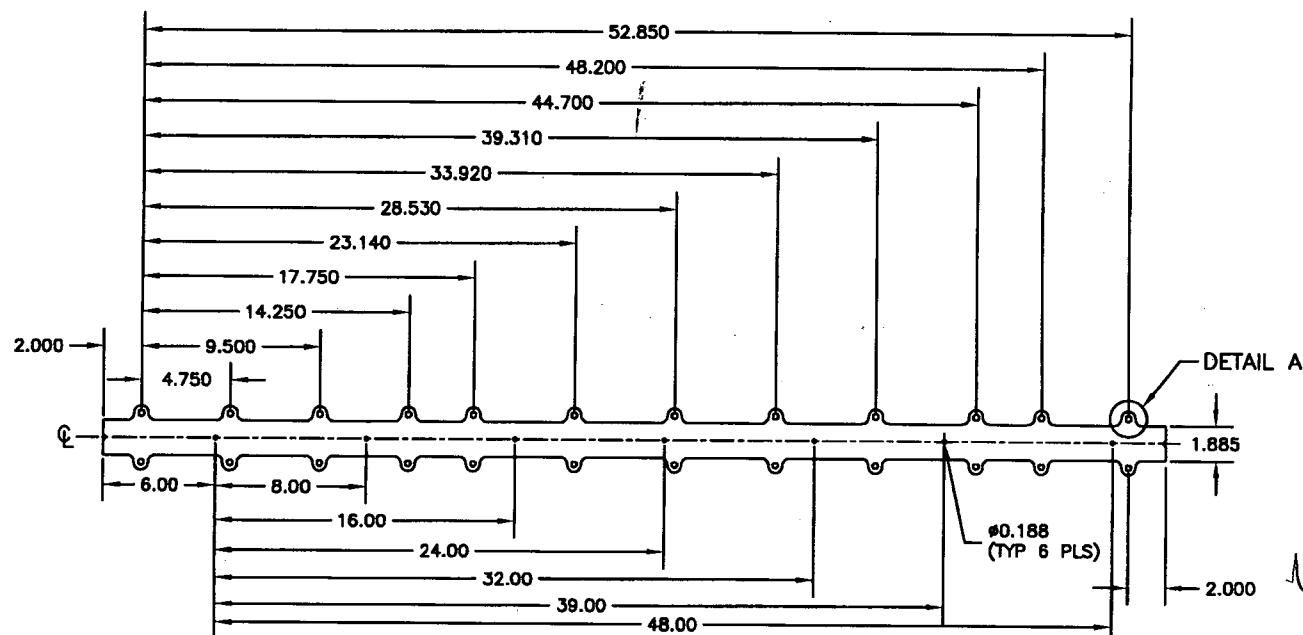
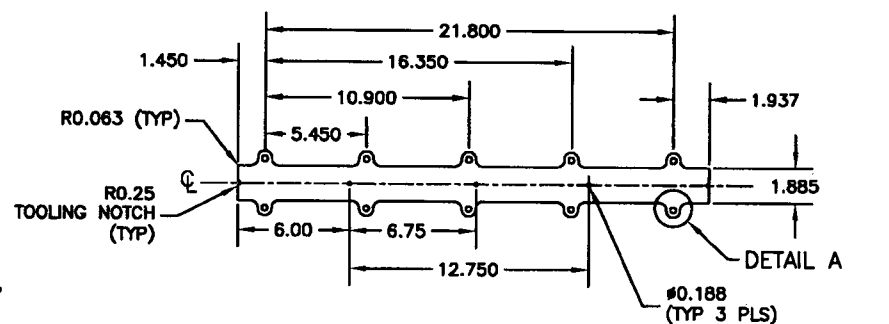
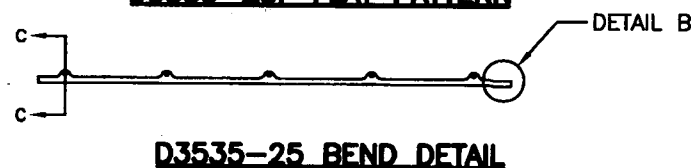
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#	#	D3535	SHEET 3 OF 7	
DATE	TITLE	WEARSHOE	SCALE	
07.04.17			1:10	

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07.04.24

2659150

**D3535-23F FLAT PATTERN****D3535-23 BEND DETAIL****D3535-25F FLAT PATTERN****D3535-25 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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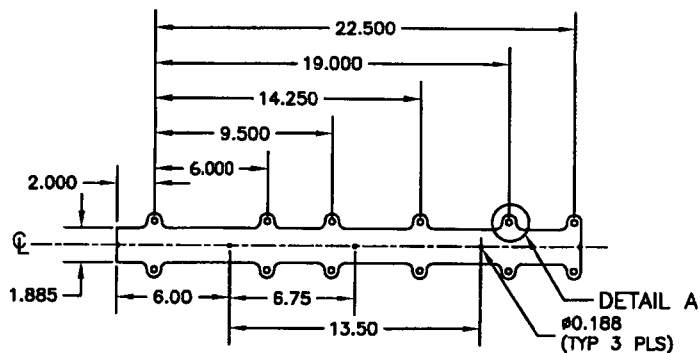
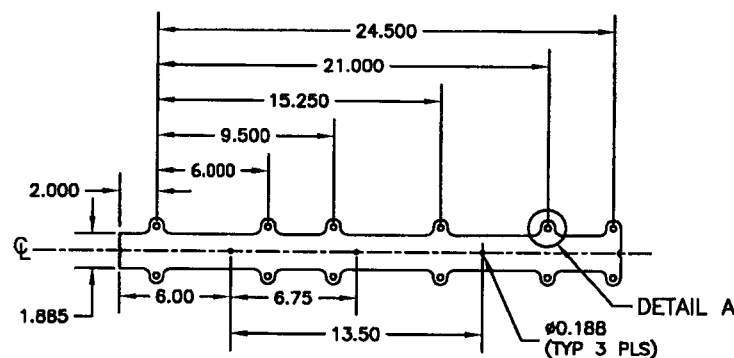
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DATE	TITLE	SCALE		
07.04.17	WEARSHOE	1:10		

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w/059130

**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
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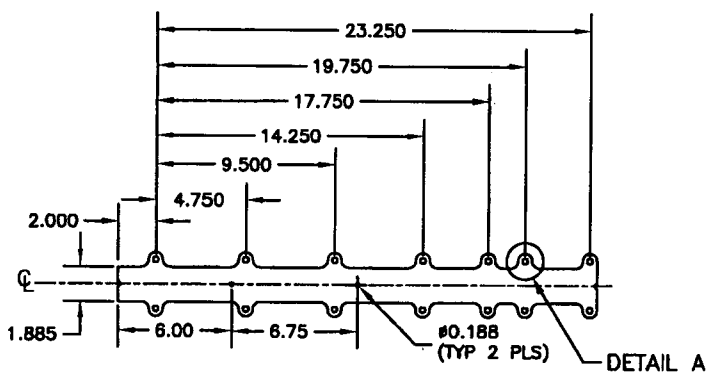
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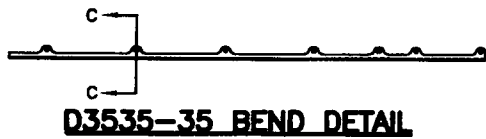
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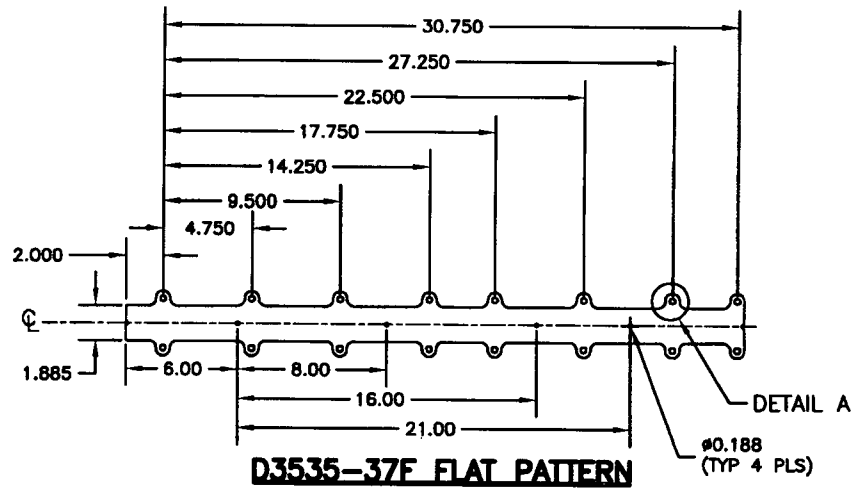
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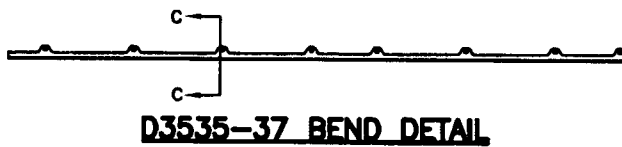
D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

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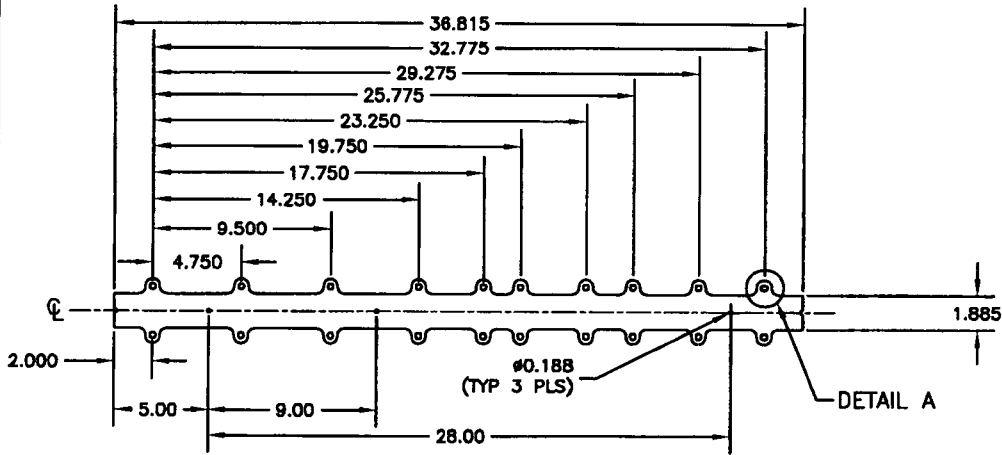
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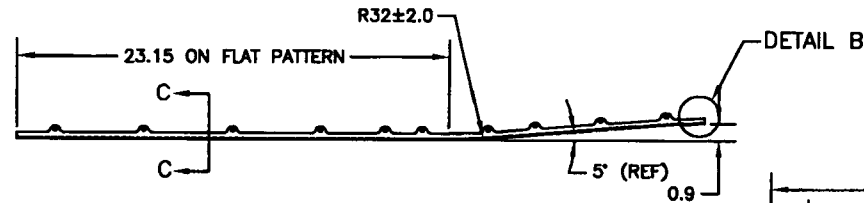
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07.04.24

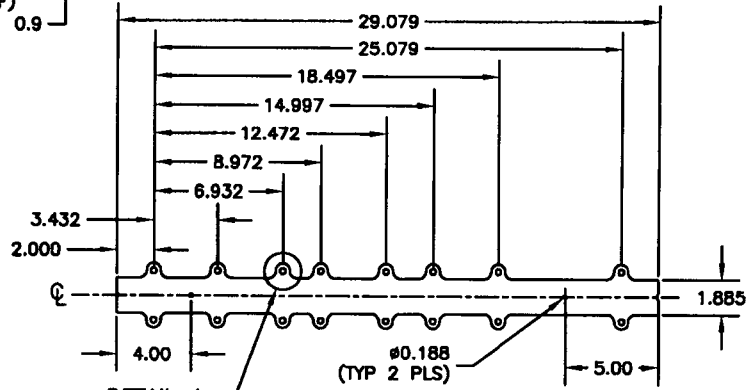
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DATE	07.04.17	TITLE	D3535	WEARSHOE
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		SHEET	6 OF 7	
		REV.	B	



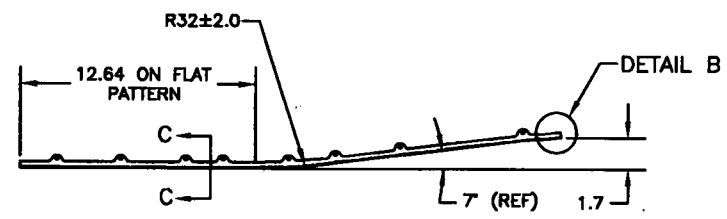
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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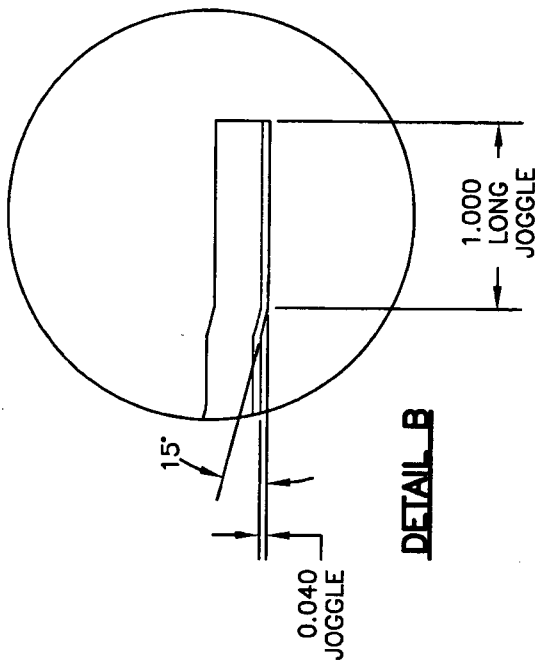
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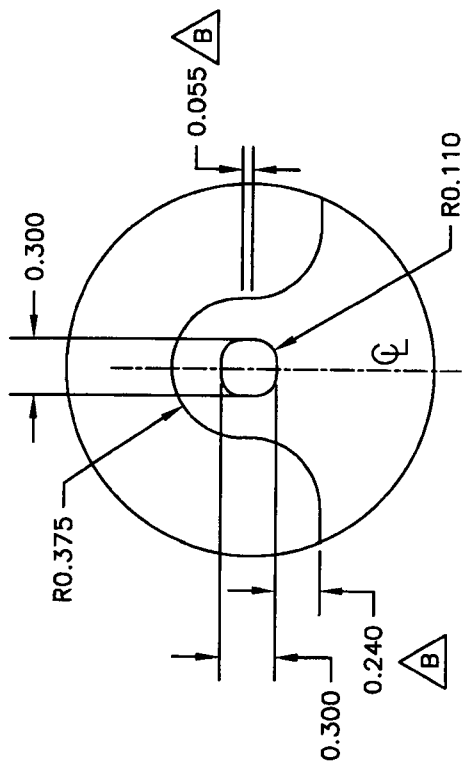
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CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

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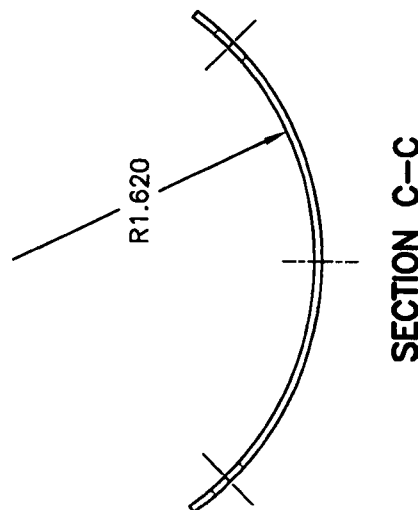
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries